

Work Order ID 60862

Monday, July 26, 2010 11:42:24 AM



Page 1

Item ID: D3564-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 7/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *H* Date: 7-7-26 Tooling: Date: QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 <input type="checkbox"/> Dwg Rev: <u>D</u> <input type="checkbox"/> Prog Rev: <u>D</u> <input type="checkbox"/> 2-								
304 . 063	Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

13 10-7-271213 10-7-2712

S10/08/03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3564-13

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Setup

Start



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Stop



Item Name: Wearshoe

Start Date: 7/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 12.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT 8179

JB 10/08/03

(12)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

D 10/08/03

(12)

Quality Control

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

11:00

☐ OVEN TEMPERATURE:320° ☐ FINISH TIME:

11:30

12 BR 10-8-5.

Powder Coating

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Work Order ID 60862

Monday, July 26, 2010 11:42:24 AM

Page 3

Item ID: D3564-13

Accept

Setup

Start

Revision ID:

Stop

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Start Date: 7/26/2010 Start Qty: 12.00

Required Date: 8/3/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

MF 10 08 05 (2)

170

Identify as per dwg & Stock Location: *FL-17* 0.00

0.00

Packaging

Memo

0.00

Packaging

12 BR-10-8-4.

180

QC21- Final Inspection - Work Order Release 0.00

0.00

QC

Memo

0.00

Quality Control

10/08/06
MF 10-8-05

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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 11:42:29 AM

Page 1

Work Order ID: 60862



Parent Item: D3564-13



Parent Item Name: Wearshoe

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ
 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	37.8267	0.222	2.804211			



304/316 Sheet .063



13 10-7-07

Location

Loc Qty

Loc Code

MAT

37.82669474

111323

0

114799

37.8266947

114799

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

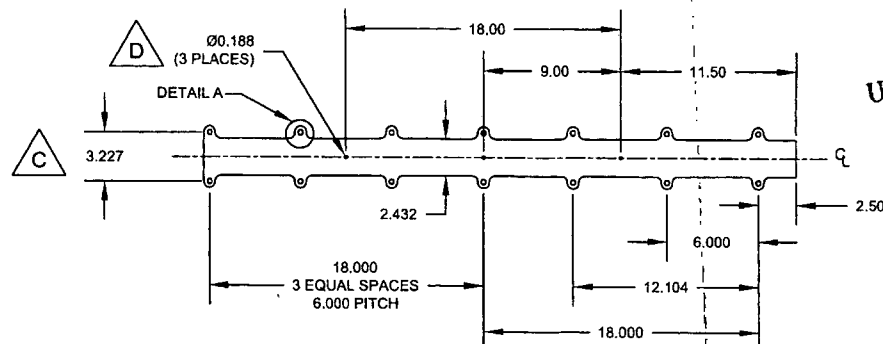
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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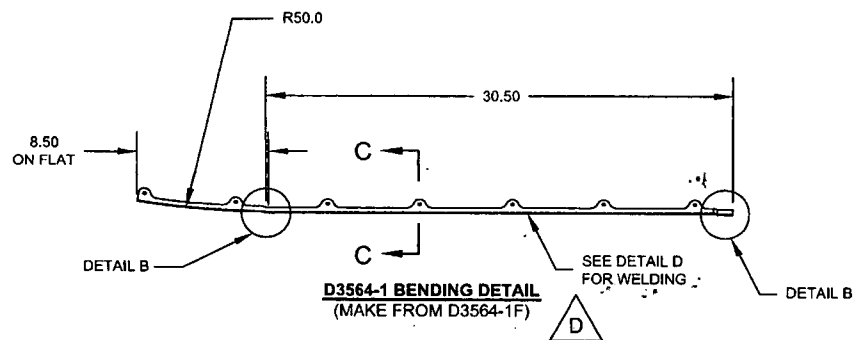
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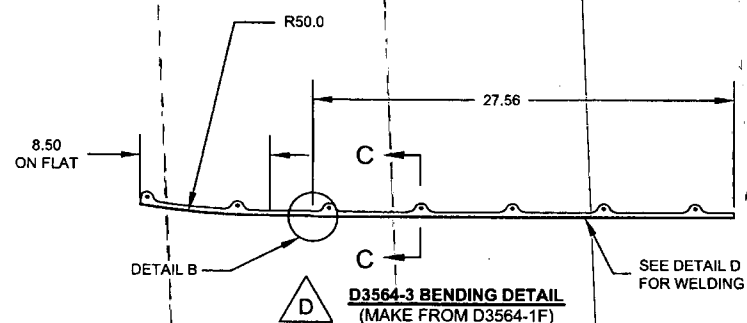
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

UNCONTROLLED COPY
SUBMITTAL
W/...
W/...
NO. 60862
B810-724

RELEASED
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE	REV. I
DRAWN	CB		SHEET 1 OF
CHECKED	PH		SCALE
MFG. APPR.	PH		1
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

8

7

6

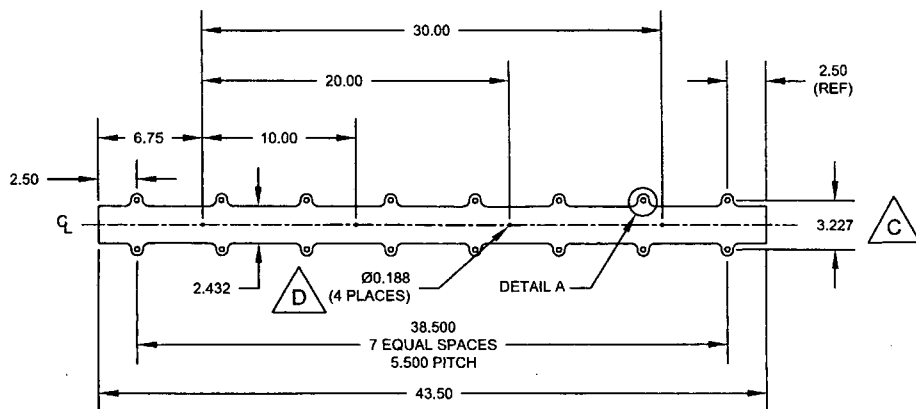
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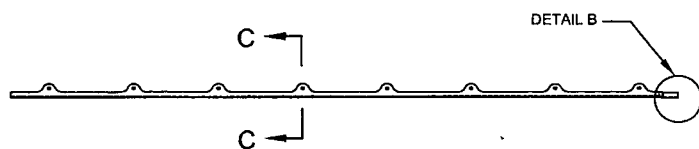
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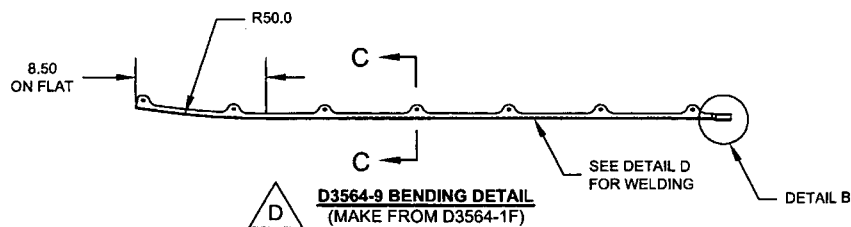
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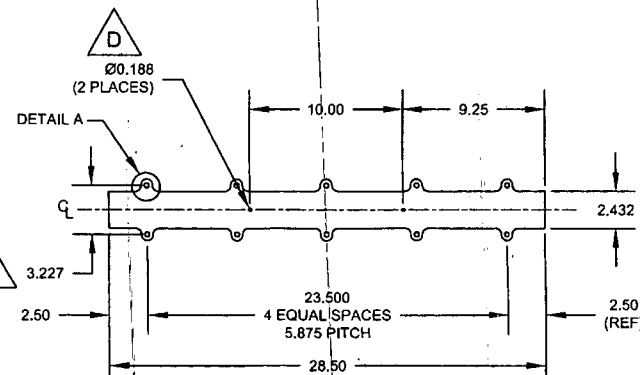
D3564-5F FLAT PATTERN



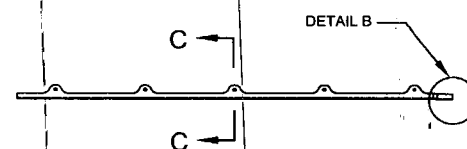
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



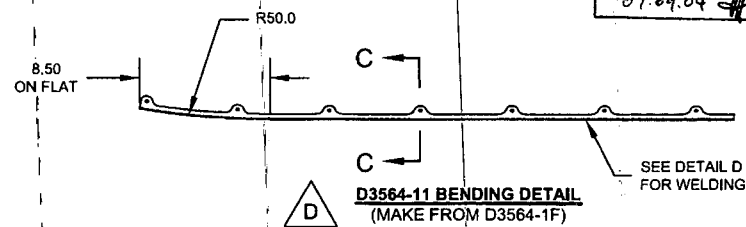
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

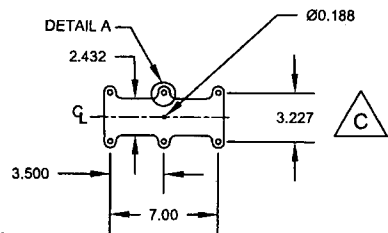
W/O:		WORK ORDER CHANGES						
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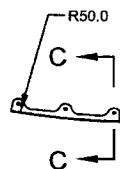
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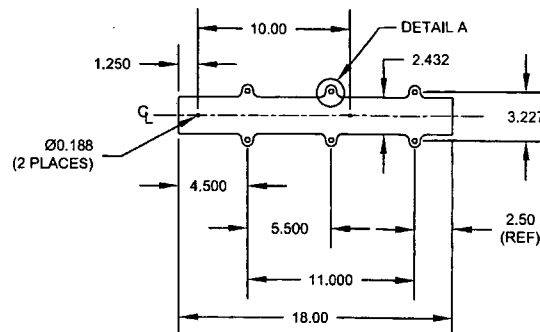
NOTE: Date & initial all entries



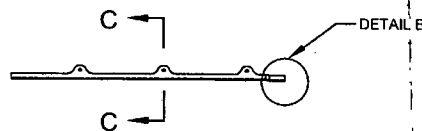
D3564-13F FLAT PATTERN



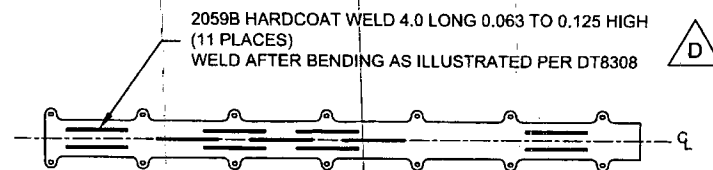
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

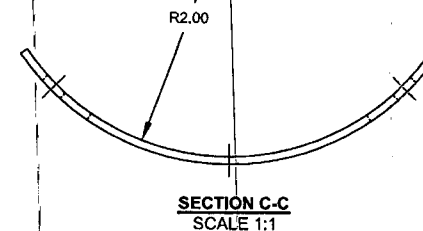


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

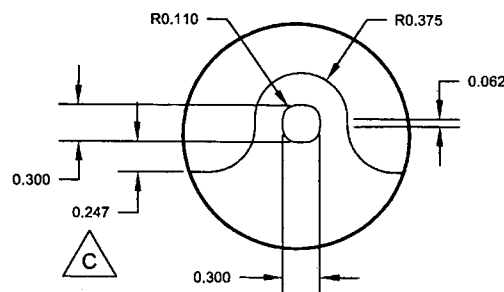
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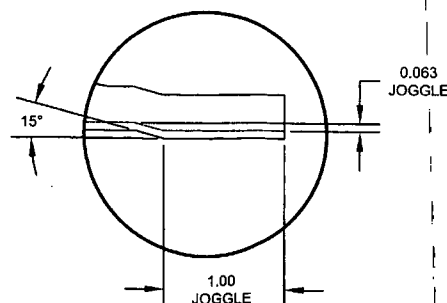
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
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